

Date: Tuesday, 8/22/2006 4:08:44 PM
 User: Kim Johnston

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BASKET BASE ASSEMBLY (350) |
| Job Number : 28291C | |
| Estimate Number : 10189 | |
| P.O. Number : N/A | Part Number : D2221 |
| This Issue : 8/22/2006 S.O. No. : N/A | Drawing Number : D2221/D2235 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : F/B1 |
| Previous Run : 28140C | Material : N/A |
| Written By : <u>[Signature]</u> | Due Date : 8/29/2006 Qty: 1 Um: Each |
| Checked & Approved By : <u>[Signature]</u> 06.08.23 | |
| Comment : Est Rev:J 05/09/02 Added D3442-1KJ/JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------|-------------|
| 1.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 4 | D3166-1 | RIB | B23094 |

PD 06-09-12 (1)

| | | |
|-----|--------|--------------|
| 2.0 | D22323 | Basket Hinge |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| | | | |
|-----|-------------|---------------|--------|
| Qty | Part Number | Description | Batch |
| 2 | D2232-3 | Hinge bracket | B24527 |

PD 06-09-12 (1)

| | | |
|-----|-------|--------------------------|
| 3.0 | D2325 | Support Gusset (350 Bask |
|-----|-------|--------------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | | |
|-----|-------------|----------------|--------|
| Qty | Part Number | Description | Batch |
| 4 | D2325 | Support Gusset | B27582 |

PD 06-09-12 (1)

| | | |
|-----|--------|----------------|
| 4.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 2 | D2327-3 | Bushing | B27051 |

PD 06-09-12 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:08:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28291C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B27587

PD

06-09-12

(1)

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B26739

PD

06-09-12

(1)

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M102001

PD

06-09-15

(1)

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M10937

PD

06-09-11

(1)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-09-20

(1)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|---------------|------|--|-----|---------------|-----|---------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector | |
| 06/09/ 26. | | Applied SilkaFlex to the before placing rivets B m101855 Exp. 02/2007 | MF. | 06/09/ 26. | | | | |
| | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/22/2006 4:08:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28291C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/09/22 ①

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-09-23

①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06-09-26

①

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/27

Job Completion



06-09-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



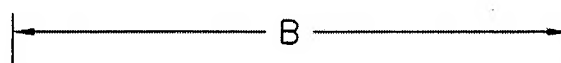
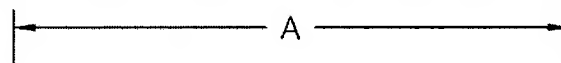
| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2221 | REV. F SHEET 1 OF 3 |
| DATE 05.06.07 | | TITLE BASKET BASE ASSEMBLY (350) | SCALE NTS |
| C | 95.11.21 | SEPARATE BASKET AND LID | |
| D | 96.06.21 | CHANGE LATCH | |
| E | 01.04.19 | CHANGE HINGE | |
| F | 05.06.07 | ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS | |

RELEASED

05.08.19 *[Signature]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|----------------|
| D2221-1 | 2 | — | 96.00 | RIB |
| D2221-3 | 2 | — | 25.50 | RIB |
| D2221-5 | 2 | 18.88 | — | RIB |
| D2221-7 | 1 | 55.25 | — | RIB |
| D2232-3 | 2 | N/A | N/A | HINGE PLATE |
| D2235-1 | 4 | N/A | N/A | RIB |
| D2325 | 4 | N/A | N/A | SUPPORT GUSSET |
| D2327-3 | 2 | N/A | N/A | BUSHING |
| D2581 | 2 | N/A | N/A | MTG BRKT |
| D3442-1 | 2 | N/A | N/A | SHIM |



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NO. 28291

D2221-1/-3/-5/-7

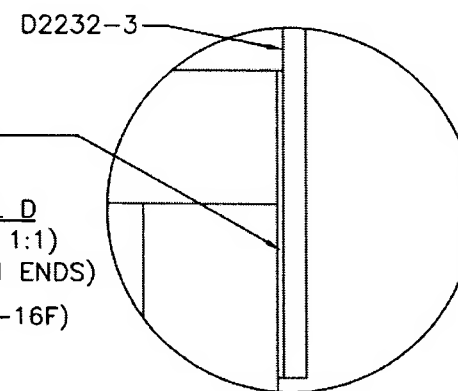
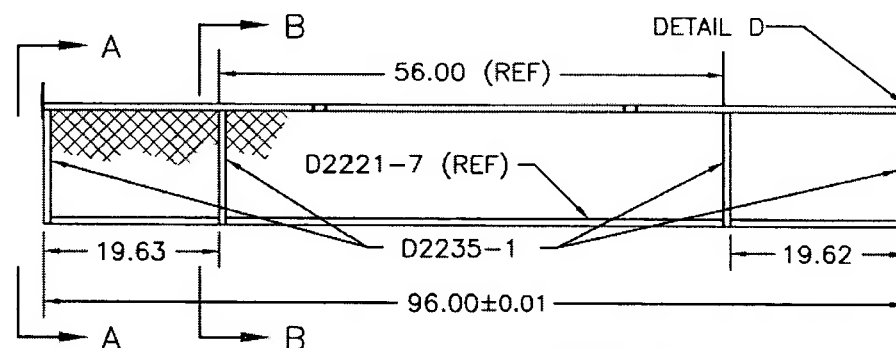
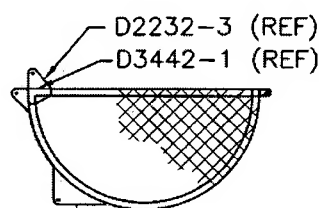
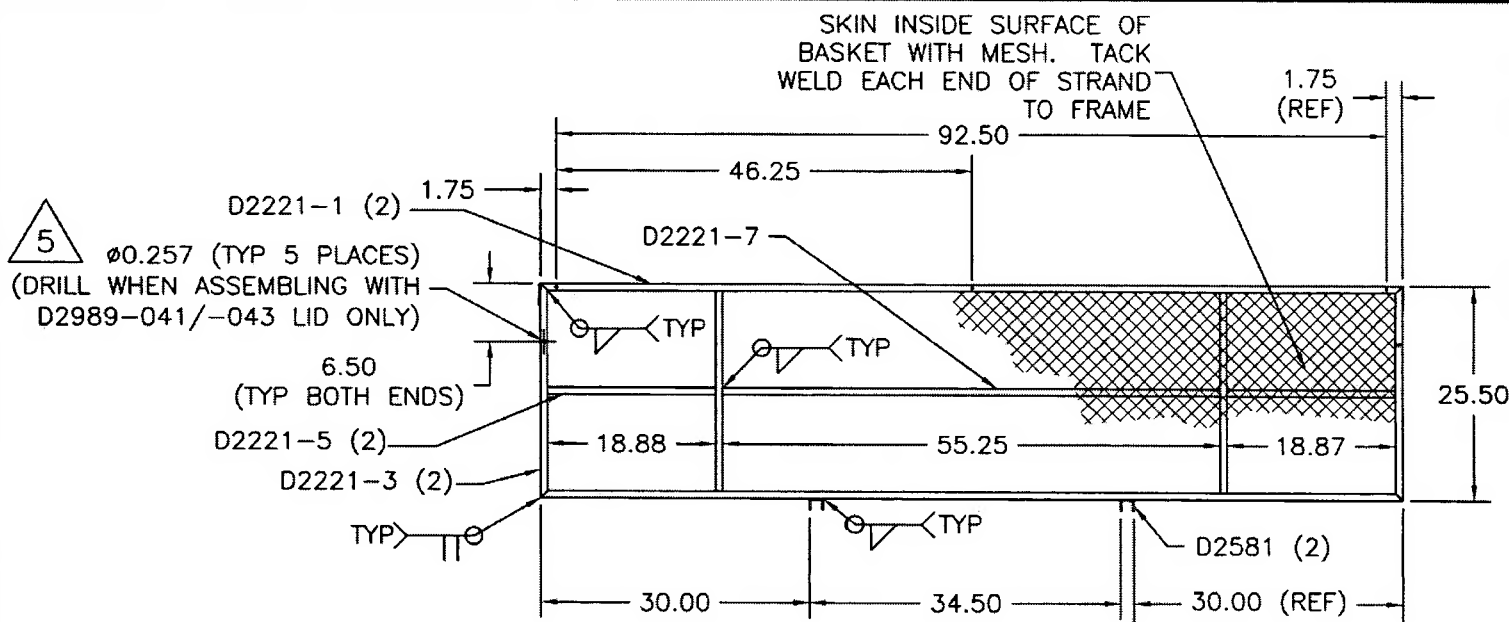
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
D2989-041/-043 BASKET LID

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|---------|----------|----------|----|-----------------------------|----------------------------|
| | | | | HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | | APPROVED | | DRAWING NO. | D2221 |
| DATE | 05.06.07 | | | TITLE | BASKET BASE ASSEMBLY (350) |
| | | | | REV. F | SHEET 2 OF 3 |
| | | | | SCALE | 1:20 |



D2325 (REF)

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WORK ORDER
20241c

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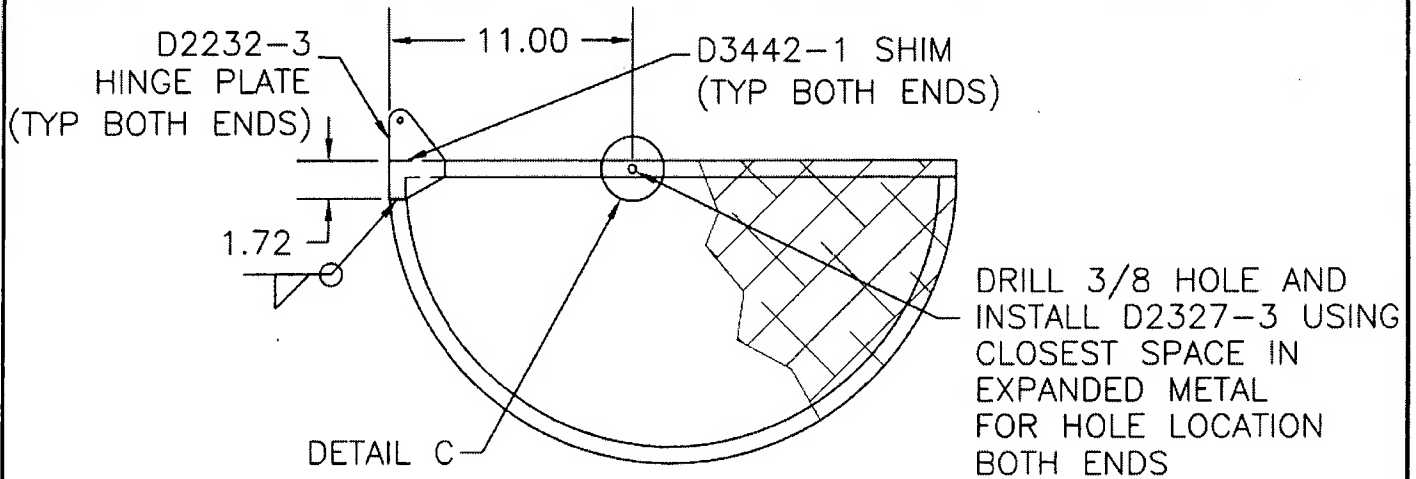
05-08-19

D2221 BASKET BASE ASSEMBLY

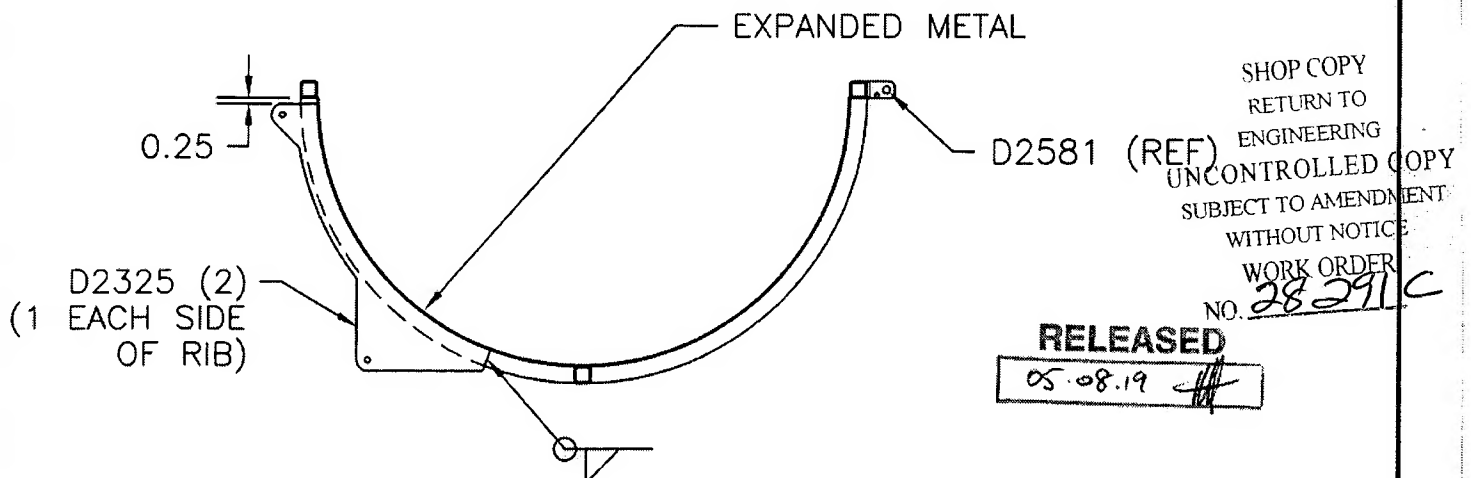
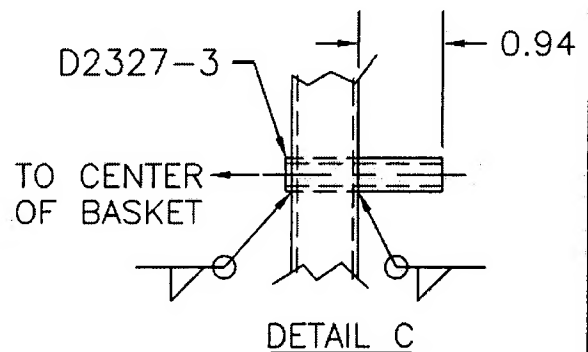
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2221 | REV. F SHEET 3 OF 3 |
| DATE 05.06.07 | | TITLE BASKET BASE ASSEMBLY (350) | SCALE 1:8 |



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

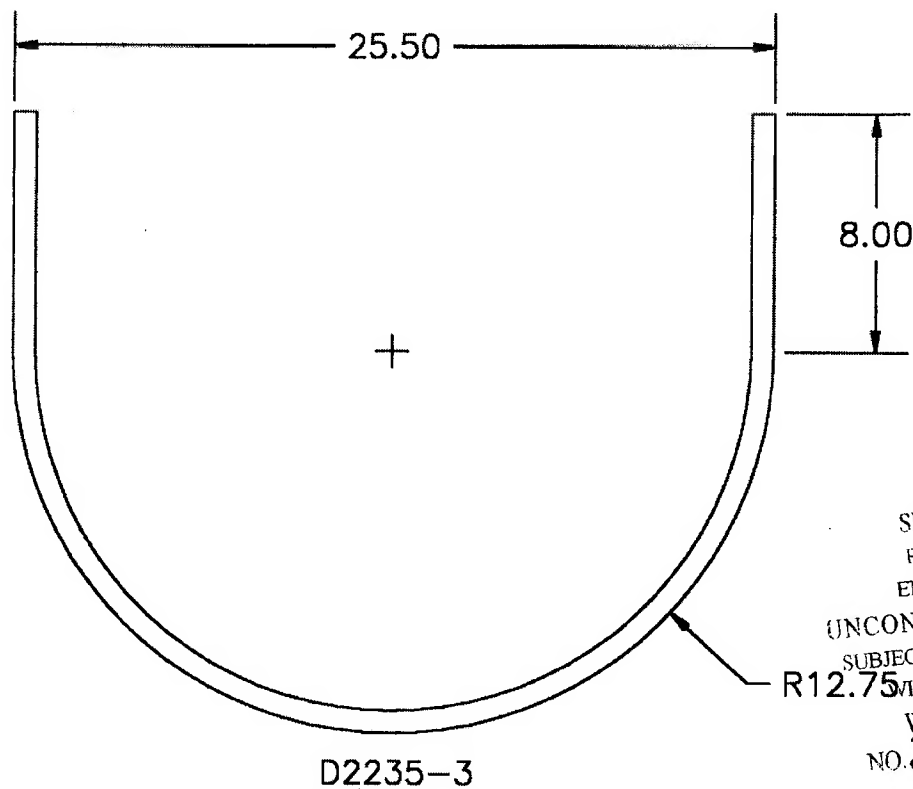
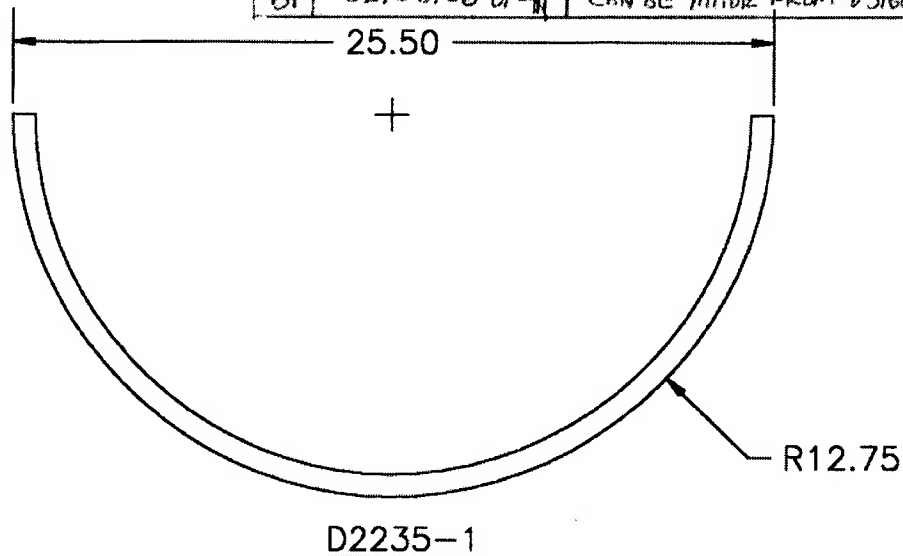
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| | | | |
|----------------------|-----------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | B WILLIAMS | DRAWING NO. | REV. B |
| CHECKED <i>BW</i> | APPROVED <i>BW</i> | D2235 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 94:12:16 | BASKET RIBS | | |
| BI | 02.08.06 <i>UP-#</i> | CAN BE MADE FROM D3166-1 | |

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R 960507



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MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.